

# Work Order ID 70614

Monday, June 13, 2011 12:33:57 PM



Page 1

Item ID: D3264-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 6/10/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-06-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3264

Rev A2

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

*BA 11/07/21*

*6 0*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOILIO REV: *44*

DWG REV: *A2*

DEBURR AS PER DWG

*11/08/22*

*6 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

C.R. 11/08/22



QC

Memo

0.00

6 0

Quality Control

130

QC8- Inspect parts - second check

0.00

B.A. 11/08/23



QC

Memo

0.00

6 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

6X 0 m 11/08/24

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Start Time: 3:45

0.00

Temp: 320°F

Finish Time: 4:15

6X Ø M-11/08/24

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

6 BR 11-8-24

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: ST144

0.00

Memo

0.00

SL

6X SP 11-0825

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, June 13, 2011 12:33:57 PM



Page 4

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Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CL 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 13, 2011 12:34:03 PM

Page 1

Work Order ID: 70614



Parent Item: D3264-1



Parent Item Name: Bracket

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.09.02 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.250X04.50  
0

Purchased

No

f

11.5167

3



6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

11.5167

✓ 112628

11.5167

3.000 ft

B.A 11/07/21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70014
<b>Description:</b> Bracket		<b>Part Number:</b>	D3264-1
<b>Inspection Dwg:</b> D3264 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.688	—		Vern	ML-7
0.063	+/-0.010	.063	—		"	"
0.125	+/-0.010	.125	—		"	"
0.875	+0.010/-0.020	.882	—		"	"
0.062	+/-0.010	.063	—		"	"
R0.03	+/-0.030	R.030	—		R-G	
R0.13	+/-0.030	R.125	—		"	
1.00	+/-0.030	1.008	—		Vern	ML-7
0.125	+/-0.010	.125	—		"	"
0.600	+/-0.010	.600	—		"	
4.000	+/-0.005	4.000	—		"	
0.750	+/-0.010	.749	—		"	
Ø0.194	+0.005/-0.000	Ø.195	—		"	
5.50	+/-0.030	5.499	—		"	
0.125	+/-0.010	.125	—		"	
0.063	+/-0.010	.063	—		"	
R0.25	+/-0.030	R.250	—		R-G	
4.27	+/-0.030	4.270	—		Vern	ML-7
R0.30	+/-0.030	R.300	—		R-G	

<b>Measured by:</b>	aw	<b>Audited by:</b>	B.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/08/22	<b>Date:</b>	11/08/23	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED

SUBJECT TO

WITHOUT

WORK ORDER

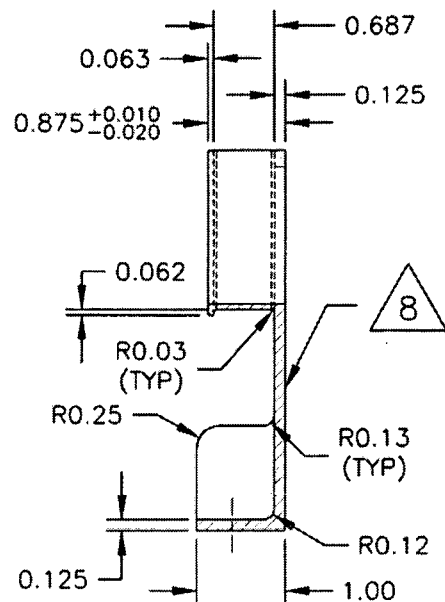
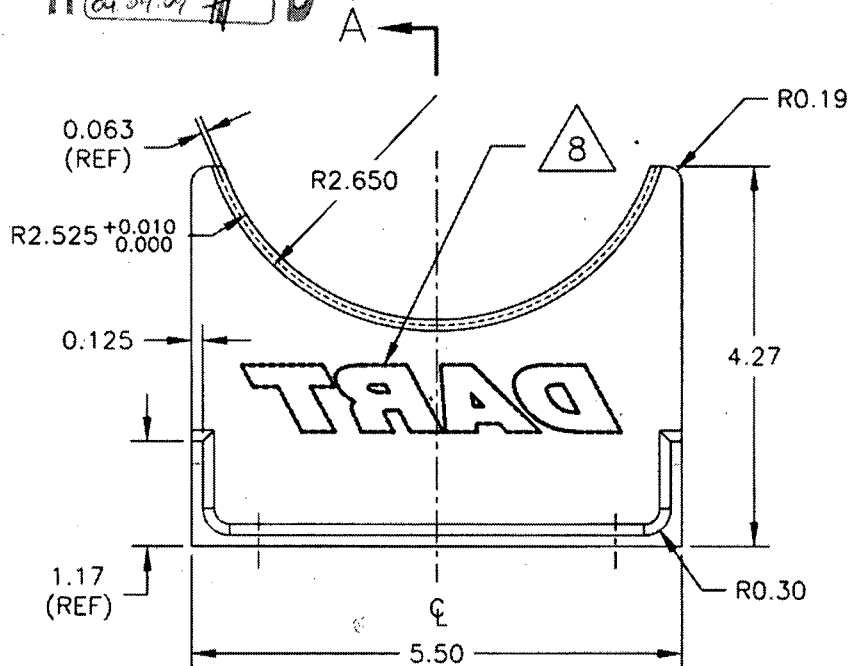
NO. 10614

**DART**

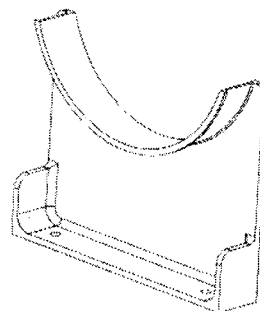
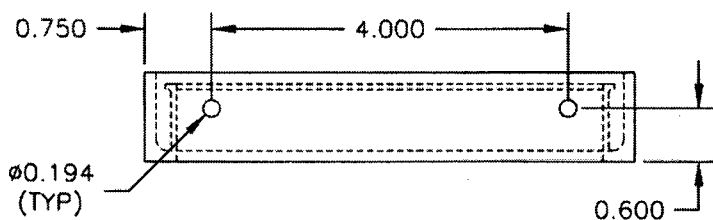


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.09.09 *[Signature]*



SECTION A-A



**D3264-1 BRACKET**

**D3264-1:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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